

Work Order ID 70746

Tuesday, June 14, 2011 10:03:43 AM



Page 1

Item ID:	D4306-044	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly, RH					
Start Date:	6/14/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	6/17/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-06-14</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4306	C

100 Weld per dwg A/R S.S. rod Batch: M115778 0.00

	Large Fab	Memo	0.00	<u>①</u>
		1- Cut tube 52"		
		2- Bend tube with manuel pipe bender as per DT9567		
		*** Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending***		
		3- Trim access tube material to finish size and cut notch as per dwg D4306-4		
		4- Drill and chamfer holes as per dwg D4306-4 using DT9710		
		5- weld bushing as per dwg D4306		
		6- grind welds flush		
		<u>SA 11-06-14</u>		
		<u>11.06.14</u> <u>①</u>		

110 QC6- Inspect dimensions to drawing 0.00

	QC	Memo	0.00	<u>②</u>
	Quality Control			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70746

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Item ID: D4306-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, RH

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8 wloc15

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11.06.15

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15

11-06-15
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 14, 2011 10:03:41 AM

Page 1

Work Order ID: 70746

Parent Item: D4306-044

Parent Item Name: Rib Assembly, RH



Start Date: 6/14/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD ver:EC
11.03.03 AS PER DWG REV.C DD ver:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1 Bushing		Manufactured	No			100	Each	311.0000	4	4		11.06.14	
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Location	Loc Qty	Loc Code
WA	200	
69202	200	
WA005	111	
66489	2	
66870	109	

M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	342.6410	4.166	4.385263		SAD 11-06-14	
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Location	Loc Qty	Loc Code
MAT018	307.3439	
117029	17.2454	
117690	91.3618	
117775	198.7367	
MAT034	35.2971	
117337	35.2971	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

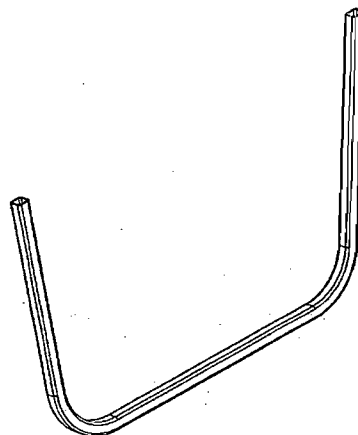
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

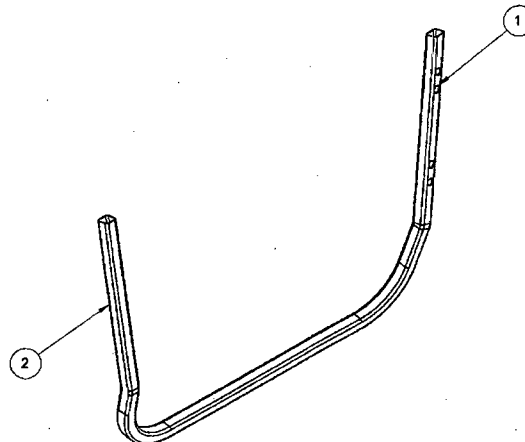
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

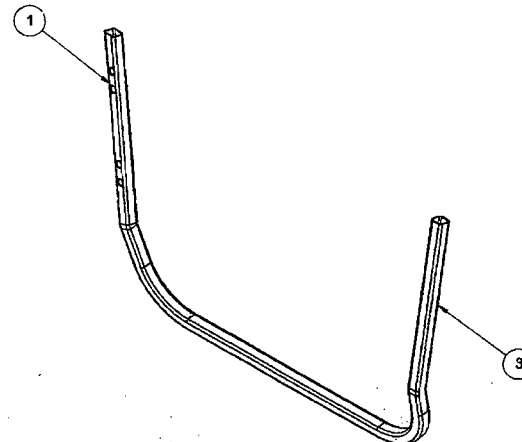
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



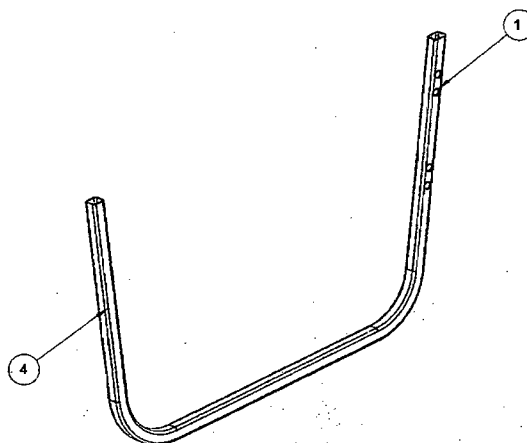
D4306-1 RIB



D4306-043 RIB ASSY, LH



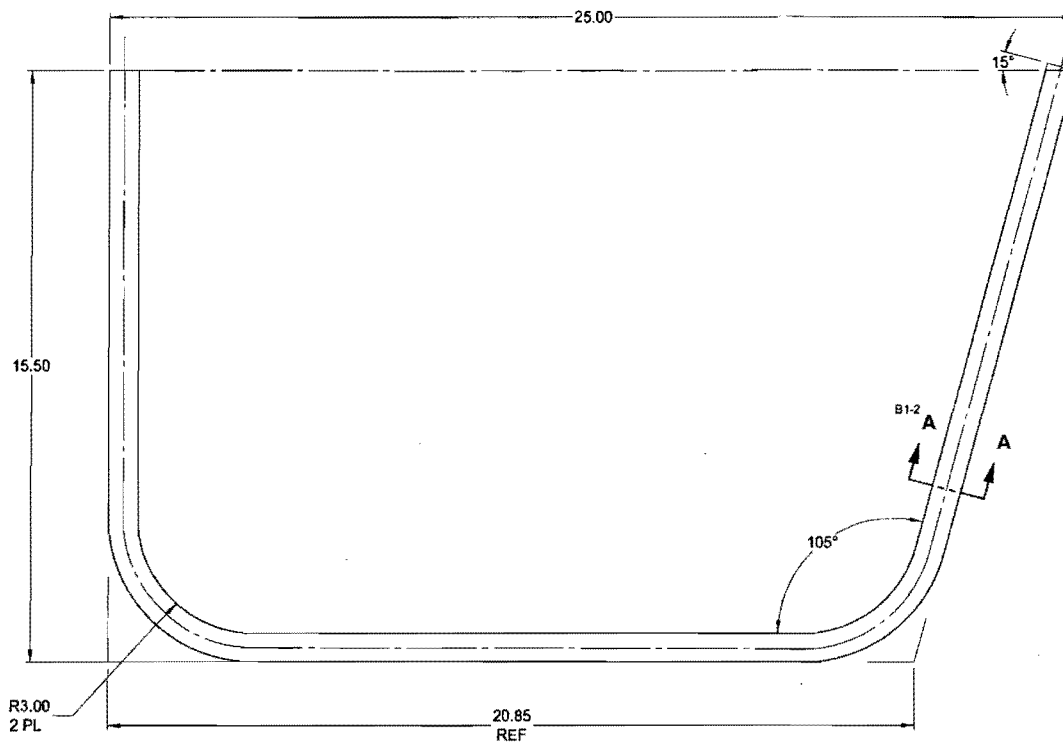
D4306-044 RIB ASSY, RH



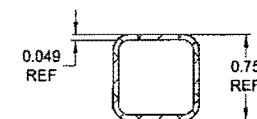
D4306-045 RIB ASSY

C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4-0); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043044 (B6-3, B3-6)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4306	SHEET 1 OF 8
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DE APPR.	SC	RIB	NTS
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2011-03-18



D4306-1 RIB



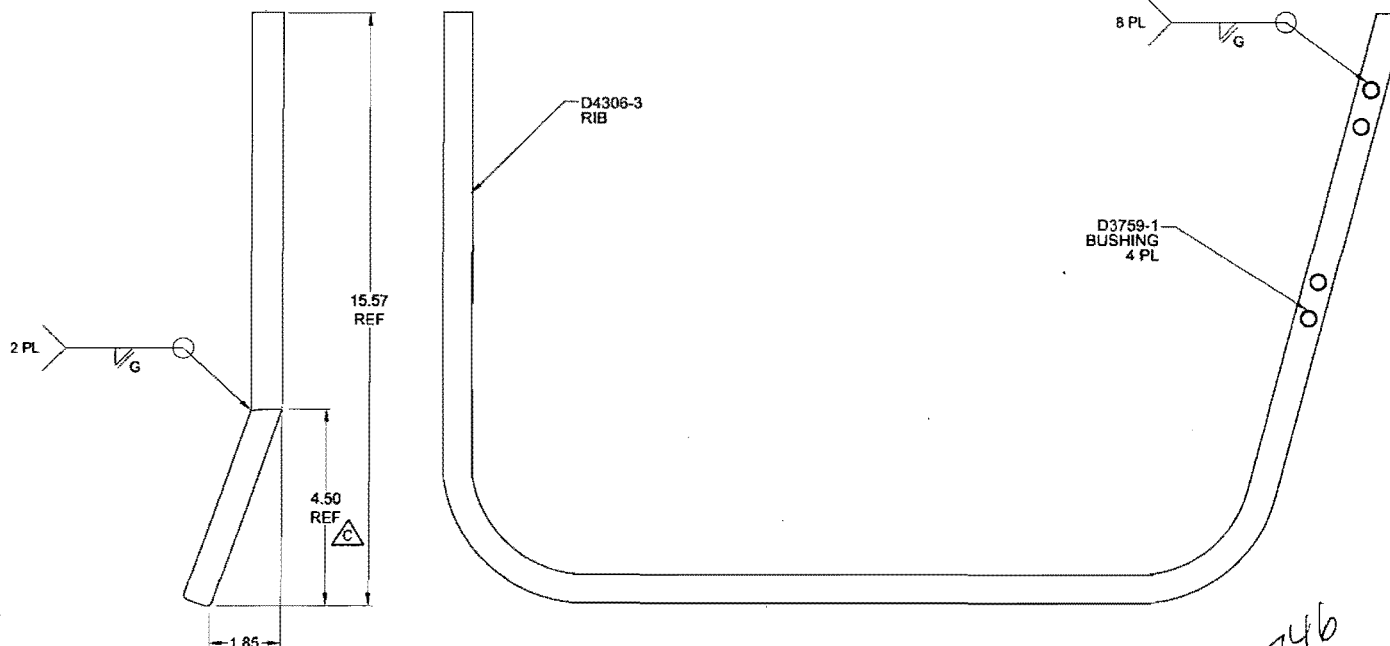
SECTION A-A B4-2

70746
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 2011-02-24
 WJD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

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D4306-043 RIB ASSY, LH

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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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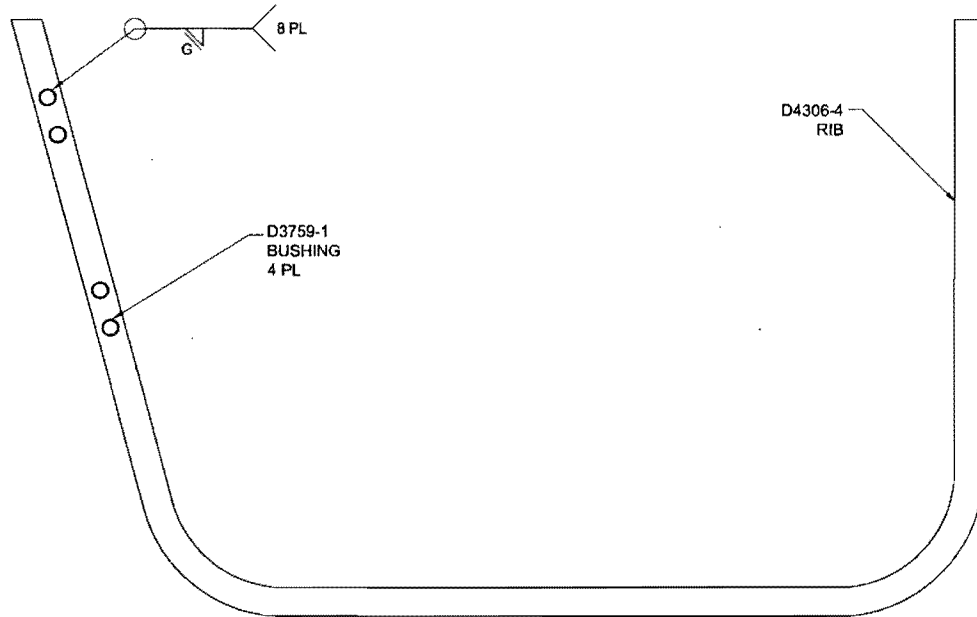
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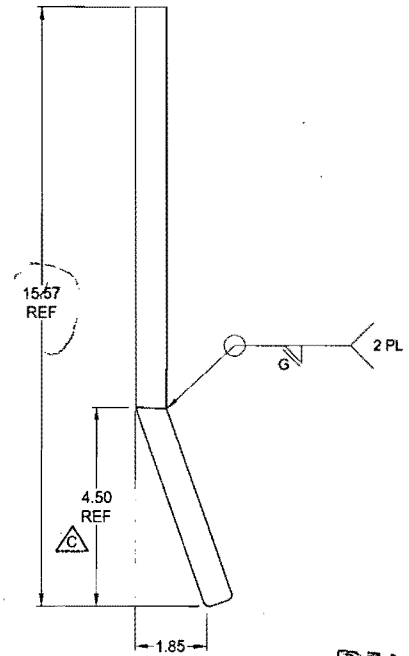
C

B

A



D4306-044 RIB ASSY, RH



NOTES:

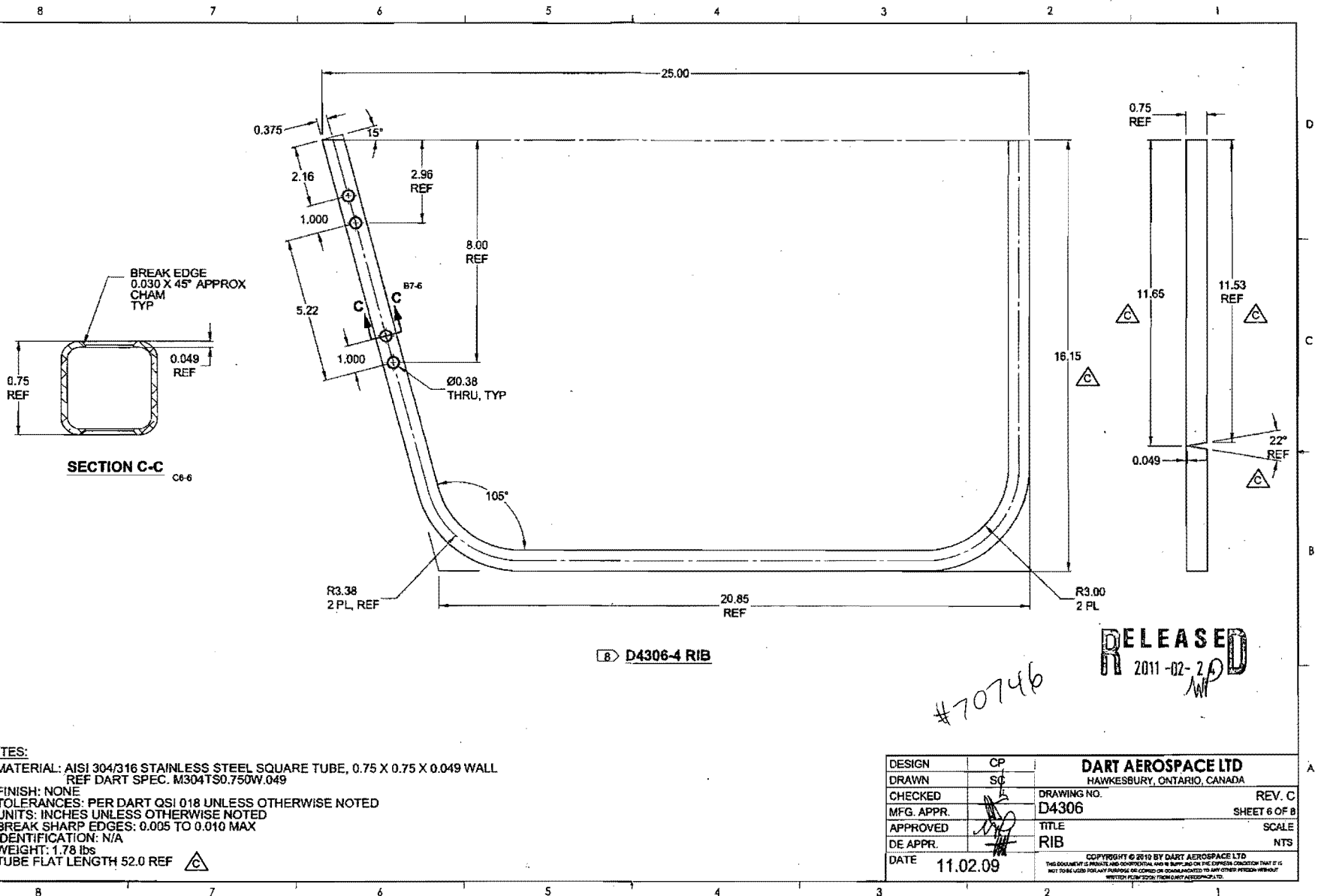
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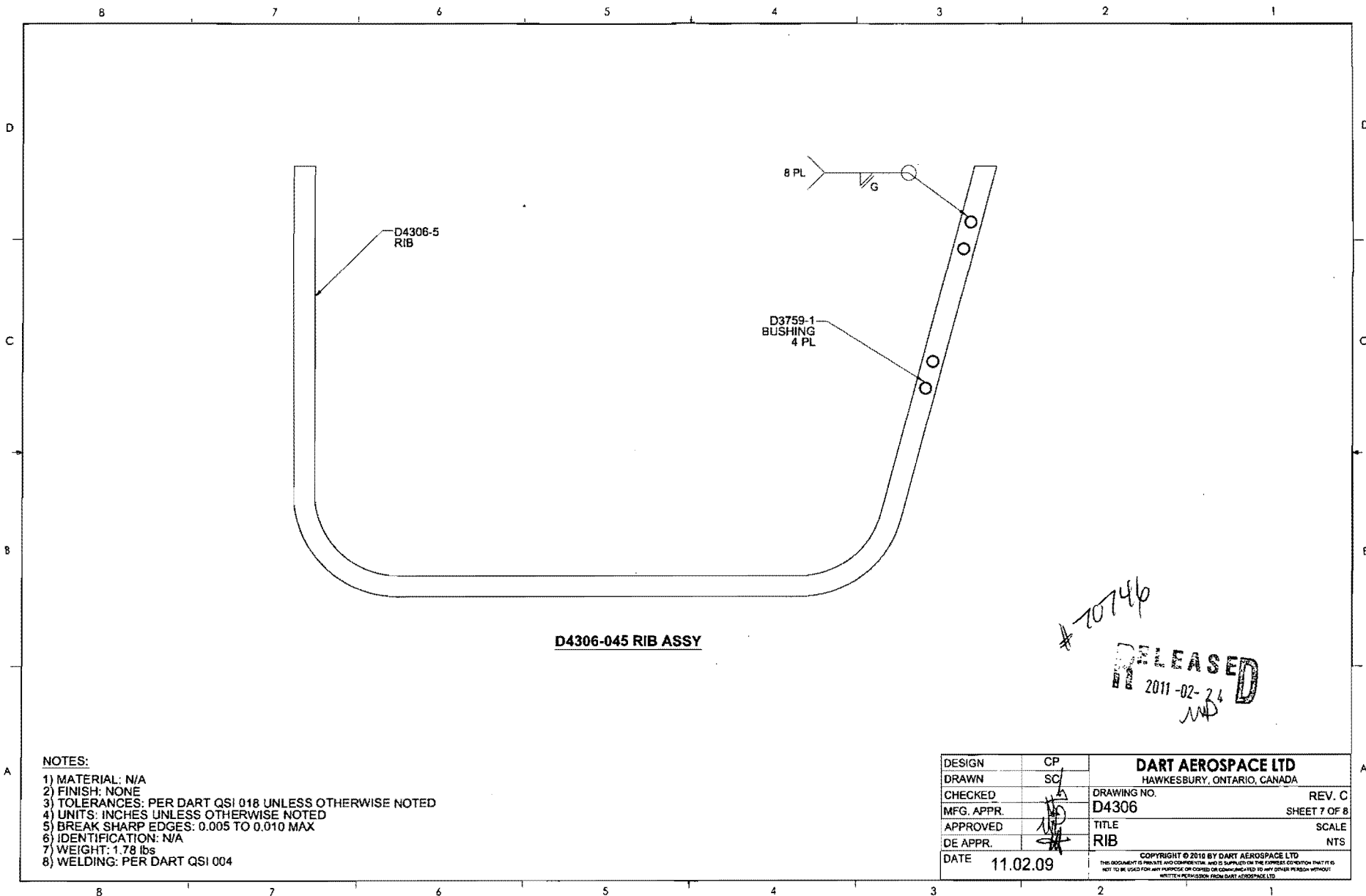
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8 7 6 5 4 3 2 1





D4306-045 RIB ASSY

NOTES:

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